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⑯ **Stabilization of water Insoluble 3-Iothiazolones.**

⑰ An isothiazolone concentrate composition is disclosed comprising an oil soluble, water insoluble 3-isothiazolone compound and a copper salt which is copper dodecylbenzene sulfonate, copper diethyl sulfosuccinate, or copper petroleum sulfonate, and an organic solvent to dissolve said 3-isothiazolone and said copper salt.

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This invention relates to stabilization of water insoluble 3-isothiazolones.

Isothiazolones are well known mildewcides for film forming compositions. Isothiazolones are generally unstable without the addition of a stabilizer. In aqueous paint formulations, copper nitrate is a well known stabilizer for isothiazolones.

5 U.S.-A-3,870795 and 4,067,878 teach the stabilization of isothiazolones against chemical decomposition by addition of a metal nitrate or metal nitrate salts, but teach that other common metal salts, including carbonates, sulfates, chlorates, perchlorates, and chlorides are ineffective in stabilizing solutions of isothiazolones, such solutions usually being in water or in an hydroxylic solvent and immiscible with solvent-soluble isothiazolones. Salts of organic carboxylic acids of more than six carbon atoms with copper are not taught or considered in these patents.

10 U.S. Patents 4,150,026 and 4,241,214 teach metal salt complexes of isothiazolones useful because of their enhanced thermal stability, while retaining biological activity. The metal salts listed do not include salts of organic carboxylic acids of more than six carbon atoms with copper, or complexes of copper with organic-soluble reagents.

15 U.S. Patent 4,608,183 teaches synergistic biocidal mixtures of isothiazolones and a metal complex with a polyfunctional ligand, requiring that the metal complex itself be a biocide. Illustrated specifically is a water-soluble cupric disodium citrate. It is known to use certain organic stabilizers for isothiazolones, generally for use situations where metal salts may create problems, such as corrosion, coagulation of latices, insolubility in non-aqueous media, interaction with the substrate to be stabilized, and the like. Formaldehyde or formaldehyde-releasing chemicals are known stabilizers, (see U.S. Patent Nos. 4,165,318 and 4,129,448).

20 EP-A-408215, published after the priority date of the present invention, discloses stabilization of water insoluble isothiazolones with water-insoluble copper compounds which are copper salts of organic carboxylic acids.

25 In certain applications it is desirable to avoid addition of organic stabilizers by virtue of their volatility, decomposition under high heat, higher cost, difficulty in handling, potential toxicity, and the like. Formaldehyde is a suspected carcinogen, and it is desirable not to use formaldehyde or formaldehyde releasing chemicals in applications where contact with human skin or lungs may occur.

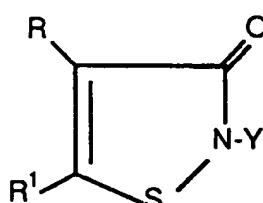
30 In actual use, copper salts of inorganic acids, such as copper (II) sulfate or nitrate, have proved efficacious in stabilization of isothiazolones. However, water-soluble inorganic copper salts are undesirable in effluent streams in such operations as in the manufacture of stabilized isothiazolones or in their blending into a product or the use of that product. Such water-soluble copper salts, especially the chlorides, may contribute to possible corrosion, or in the presence of polymers in aqueous dispersion may lead to coagulation of the dispersion. The water-soluble salts may not be readily miscible with certain of the water-insoluble isothiazolones, leading to separation and lowering of stability of a stabilizer concentrate.

35 Grove, U.S. Patent 4,783,221 discloses the use of metal salts of organic carboxylic acids containing at least 6 carbon atoms wherein the metal is selected from the group consisting of copper and other transition metals, zinc, antimony, and lead, with an isothiazolone compound, and a solvent/diluent to preserve wood. Stabilization of the isothiazolone by the copper compounds is not disclosed.

40 It is therefore an object of the present invention to provide a mildew-resistant paint composition which avoids the problems of previous metal salt stabilizers.

45 These objects, and others as will become apparent from the following description, are achieved by the present invention which in one aspect provides a composition comprising

50 a) an oil soluble, water insoluble 3-isothiazolone compound of the formula:



55 wherein Y is an alkyl group of 2 to 18 carbon atoms optionally substituted with hydroxy, halo, cyano, alkylamino, dialkylamino, phenylamino, halophenylamino, carboxy, carbalkoxy, alkoxy, aryloxy, morpholino, piperidino, pyrrolidonyl, carbamoxy, or isothiazolonyl, wherein the total number of carbon atoms in the substituted alkyl group does not exceed 18; an unsubstituted or halo-substituted alkenyl group of 4 to 18 carbon atoms; an unsubstituted or halo-substituted alkynyl group of up to 18 carbon atoms; an unsubstituted or alkyl-

substituted cycloalkyl group having a four to six carbon atom ring and up to 12 carbon atoms; an unsubstituted or a halo-, lower alkyl-, or lower alkoxy-substituted aralkyl group wherein the total number of carbon atoms in the aralkyl group does not exceed 10; or an unsubstituted or a halo-, nitro-, lower alkyl-, or lower carbalkoxy-substituted aryl group wherein the total number of carbon atoms in the aryl group does not exceed 10; and

- 5 R and R¹ are each independently hydrogen, halogen, or a (C₁-C₄) alkyl group;
- b) copper dodecylbenzene sulfonate, and/or copper dioctyl sulfosuccinate and/or copper petroleum sulfonate in an amount sufficient to stabilize said isothiazolone against chemical degradation;
- c) optionally an organic solvent.

One skilled in this art would recognize that the water solubility of the isothiazolones depends on the type 10 of substituent (i.e. R, R¹ and Y). For example, the carbon content of the alkyl group will vary depending on the R or R¹ or both the R and R¹ substituent. As further illustration of what is meant is that, for example, when R=R¹=halo, the alkyl group can be as low as two carbon atoms and the water solubility will be less than 1%. When only one of the R or R¹ is halo and the other hydrogen, the alkyl group must be at least four carbon atoms to produce sufficiently low solubility. When both R and R¹ is hydrogen then the alkyl group must be at least six 15 carbon atoms.

In another aspect, the invention comprises a method of preventing or inhibiting the growth of bacteria, fungi 20 or algae in a locus susceptible or subject thereto, comprising incorporating into or onto the locus, in an amount effective to adversely affect said growth, a composition as defined above. In particular, the compositions of the present invention are useful for preventing mildew in paint compositions.

Other aspects of the invention include a method of stabilizing a 3-isothiazolone against chemical decomposition, comprising incorporating therewith an effective amount of copper dodecylbenzene sulfonate, copper dioctyl sulfosuccinate and/or copper petroleum sulfonate; and the use of copper dodecylbenzene sulfonate, copper dioctyl sulfosuccinate or copper petroleum sulfonate as stabilizers for 3-isothiazolones.

Compositions containing from 0.01 to 30% by weight of the compositions of the invention, water and an 25 emulsifier are also envisaged within the scope of the invention, as are articles containing the compositions of the invention as microbicides.

The isothiazolones useful in the invention are well known and are described in U.S.-A-3,523,121 and 3,761,488. Highly preferred isothiazolones are 2-octyl-3-isothiazolone and 4,5-dichloro-2-octyl-3-isothiazolone.

30 The oil soluble copper compounds useful in the invention are copper dodecylbenzene sulfonate, copper dioctyl sulfosuccinate, and copper petroleum sulfonate.

Solvents may be used to dissolve the isothiazolones and may be any organic solvent which is miscible 35 with the isothiazolones, is compatible with the proposed end use, does not destabilize the isothiazolone, and does not react with the copper salt to eliminate its stabilizing action.

Hydroxylic solvents, for example, polyols, such as glycols, monoethers of glycols, alcohols, and the like, 40 may be used. An hydroxylic coalescent, such as Texanol (trimethyl-1,3-pentanediol monoisobutyrate) also may be used. In certain formulations, hydrocarbons, either aliphatic or aromatic, are useful solvents. Typical solvents are dipropylene glycol, dipropylene glycol monoethyl ether, xylene, mineral spirits, and the like. Solvents may be used in admixture as long as the copper salt remains soluble or is well dispersed enough so as to be added conveniently and uniformly to the test formulation.

The amounts of copper salt employed will vary depending on use conditions and concentrations of the isothiazolone in the mixture. Generally, when solvent is present, from about 0.01 to about 50 parts of said isothiazolone (b); from about 0.0001 to about 10 parts of said copper compound (c), and which further comprises from about 40 to about 99.9899 parts of a solvent can be used. Preferably, ratios of from 1 to 25 parts of (b), 45 from 0.1 to 10 parts of (c) and from 65 to 98.9 parts of the solvent are suitable. In more concentrated solutions, effective amounts of copper salt based on isothiazolone are in the ratios of from about 1:50 to about 2:1. Obviously higher amounts may be used, but at additional cost. At high levels of dilution of this isothiazolone (such as from 1 to 2 percent isothiazolone in the solvent), the ratio of stabilizer to isothiazolone can range from about 1:10 to about 3:1.

50 Other salt stabilizers such as those described in U.S.-A- 3,870,795; 4,067,878; 4,150,026 and 4,241,214 can also be included.

Because the preferred isothiazolones and the stabilizers of the present invention are both organic-soluble and water-insoluble, they may be used in aqueous dispersions or latices, as both will diffuse into the organic polymer and be efficacious when the polymer is isolated by drying of the latex to form a film. The preferred 55 isothiazolones and stabilizers of the present invention may also be used in oil or alkyl paint formulations.

It is known in the art that the performance of microbicides can frequently be enhanced by combination with one or more other microbicides. In fact, there have been numerous examples of synergistic combinations. Thus, other known microbicides may be combined advantageously with the stabilized isothiazolones of this invention.

One of the major applications of the compositions of the present invention is as mildewcides for paints. The isothiazolone and copper compound may be separately blended into the paint to be stabilized or, preferably, the isothiazolone and the copper compound, with or without organic solvent, may be precombined into a single package or solution before being added to the paint to be stabilized. The single package combination of isothiazolone, copper compound, and optional organic solvent offers the advantage of improved control of the ratio of isothiazolone to copper compound being added to the paint since a single operation is involved rather than the several steps involved when each ingredient is added separately. In addition, the paint formulator will require only one storage vessel for single-package formulations, rather than the several which would be required if each component were to be supplied separately. Also, a one-step operation is inherently simpler than the multistep process of adding each ingredient separately where the chance for spillage or error is increased.

10 The following examples illustrate a few embodiments of the present invention. All percentages are by weight unless otherwise specified.

15 **EXAMPLES**

1. Preparation of copper salts useful in the invention

20 **A. Copper dioctyl sulfosuccinate**

25 Into a fritted column was added: 12 g (12 meq H⁺) ion exchange resin (Amberlite[®] IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 7 g (10 meq) sodium dioctyl sulfosuccinate (Triton[®] GR-5M brand), 7 g water, and 7 g isopropanol. The surfactant solution was run through the column and collected in a 100 ml beaker containing: 0.5 g (10 meq Cu) copper hydroxide and 20 g water. The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene, the toluene solubles were dried with molecular sieve, rotary evaporator stripping removed the toluene, and the resulting solids were vacuum dried overnight at room temperature.

30 A blue-green semi-solid product was isolated. Recovery was near 100%. Elemental analysis (expect/found): C 53.0/50.4, H 8.2/9.5, Cu 7.0/7.3, S 7.1/6.0 and Cu/S 0.99/1.22.

B. Copper Dodecylbenzene sulfonate

35 Into a fritted column was added: 12 g (12 meq H⁺) ion exchange resin (Amberlite[®] IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 8.6 g (10 meq) dodecyl benzene sulfonate (Biosoft D-40 brand), 7 g water, and 7 g isopropanol. The Biosoft D-40 solution was run through the column and collected in a 100 ml beaker containing: 0.58 g (12 meq Cu) copper hydroxide mixture and 20 g water. The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene. The toluene solubles were dried with molecular sieve. Stripping, on a rotary evaporator removed the toluene, and the resulting solids were vacuum dried overnight at room temperature.

40 A blue-green waxy product was isolated. Recovery was near 100%. Elemental analysis (expect/found): C 61.0/53.4, H 8.2/9.2, Cu 8.9/7.7, S 9.0/7.5 and Cu/S 0.99/1.03.

45 **C. Copper petroleum sulfonate**

50 Into a fritted column was added: 12 g (12 meq H⁺) ion exchange resin (Amberlite[®] IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 10 g (10 meq) petroleum sulfonate (Petronate HL brand), 7 g water, and 7 g isopropanol. The Petronate HL solution was run through the column and collected in a 100 ml beaker containing: 0.5 g (10 meq Cu) copper hydroxide and 20 g water. The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene, the toluene solubles were dried with molecular sieve, rotary evaporator stripping removed the toluene, and the resulting solids were vacuum dried overnight at room temperature.

55 A blue-green waxy product was isolated. Recovery was near 100%. Elemental analysis (expect/found): C 65.2/64.3, H 10.9/10.0, Cu 4.3/4.3, S 4.4/4.4 and Cu/S 0.98/0.99.

D. Copper dodecylbenze sulfonate from dodecylbenzene sulfonic acid (DBSA).

5 A 500 ml r.b. flask was fitted with a Barrett trap, water cooled condenser and magnetic stirrer. Into the flask 100 ml Solvesso 100, 120 g (0.36 moles) Naxel AAS-98S (98% Linear DBSA) and 25 g (0.26 moles) of copper hydroxide were added. The flask was heated to approximately 170°C in an oil bath and the mixture was refluxed with stirring for 4 1/2 hours. Six ml of water of neutralization was collected in the trap. The cooled solution was diluted with an additional 250 ml Solvesso 100 and filtered after standing. The brown solution contained 2.7% Cu as the dodecyl benzene sulfonate salt.

10 2. Preparation of Comparative Copper Salts Not Useful in the Invention (Comparative)

A. Alkyl naphthalene sulfonate

15 Into a fritted column were added: 12 g (12 meq H⁺) ion exchange resin (Amberlite® IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 3.8 g (10 meq) alkyl naphthalene sulfonate (Morewet B brand), 7 g water, and 7 g isopropanol. The Morewet B solution was run through the column and collected in a 100 ml beaker containing: 0.5 g (10 meq Cu) copper hydroxide and 25 g water. The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene, the toluene solubles were dried with molecular sieve, rotary evaporator stripping removed the toluene. Essentially no material was recovered indicating the reaction product (if any) was not soluble in aromatic hydrocarbon or useful in the practice of this invention.

20 B. Linear alkene ("olefin") sulfonate

25 Into a fritted column were added: 12 g (12 meq H⁺) ion exchange resin (Amberlite® IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 7.5 g (10 meq) linear alkene sulfonate (Witconate AOS brand), 7 g water, and 7 g isopropanol. The Witconate AOS solution was run through the column and collected in a 100 ml beaker containing: 0.5 g (10 meq Cu) copper hydroxide and 25 g water. 30 The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene, the toluene solubles were dried with molecular sieve, rotary evaporator stripping removed the toluene. No material was recovered after the toluene was removed.

35 C. Alkyl taurate

40 Into a fritted column were added: 12 g (12 meq H⁺) ion exchange resin (Amberlite® IR 120 brand). Resin beads were washed with 100 ml deionized water. Into a 50 ml beaker were added: 6.4 g (10 meq) sodium alkyl taurate (Igepon T-77 brand), 7 g water, and 7 g isopropanol. The Igepon T-77 solution was run through the column and collected in a 100 ml beaker containing: 0.5 g (10 meq Cu) copper hydroxide and 25 g water. The effluent/copper hydroxide mixture was swirl mixed while collecting the effluent. A 10 g water rinse of the column was added to the copper mixture. Extraction of the beaker's contents was done with 2 x 25 ml toluene, the toluene solubles were dried with molecular sieve, rotary evaporator stripping removed the toluene, and the resulting solids were vacuum dried overnight at room temperature.

45 A green blue solid product was isolated. Recovery was low (<10% of the calculated) Elemental analysis (expect/found): C 48/57.0, H 9.3/10.6, Cu 7.3/10.9, S 7.4/0.9 and Cu/S 0.99/12.0, indication lack of sulfonic functionality.

50 3. Stabilization of 3-Iothiazolones with copper salts of the invention

55 The solid test materials were each mixed with Aromatic 150 to prepare stabilizer solutions. The stabilizer solutions and 4,5-dichloro-2-n-octyl-3-isothiazolone (IT) (100% ai) were charged into AC-64 latex paint (formulation listed in Appendix) to give 27 ppm Cu and 900 ppm 4,5-dichloro-2-n-octyl-3-isothiazolone ai. These paints were heat aged at 60°C and were sampled at 0 time, 5 days and 10 days. The sampled material was analyzed for ppm ai remaining. Results are listed in Table I.

Table I
Dichloro Octyl Isothiazolones + Copper Stabilizers
Heat Aged at 60°C

5

<u>Stabilizer</u>	<u>Color</u>	<u>Charged</u>	<u>% RH-287 Remaining</u>			
		<u>Isothiazolone PPM</u>	<u>Copper PPM</u>	<u>0 Days</u>	<u>5 Days</u>	<u>10 Days</u>
IT Control		900	0	100	0	0
Cu-Biosoft D-40	Blue-Green	900	27	100	100	20
Cu-Triton GR-5M	Blue-Green	900	27	100	100	100
Cu-Petronate HL	Green-Blue	900	27	100	100	100

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Paint Compositions comprising 3-Iothiazolone stabilized

with Copper Salts

AC-64 LATEX PAINT FORMULATIONS

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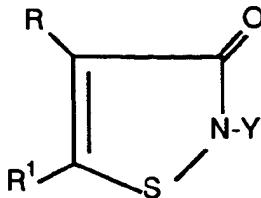
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<u>Material</u>	<u>1b/50 gal</u>
Natrosol 250 MHR	1.5
Ethylene glycol	12.5
	<u>Premix</u>
Water	56.0
Tamol 960 (40%)	3.6
KTPP	0.75
Triton CF-10	1.3
Colloid 643	0.5
Propylene glycol	17.0
Ti-Pure R-902	112.5
Minex 4	79.7
Icecap K	25.0
Attagel 50	2.5
	<u>Let Down</u>
AC-64 (60.5%)	153.0
Colloid 643	1.5
Texanol	4.7
Ammonia (28%)	1.16
Natrosol 250 MHR (2.5%)	53.50
Water	54.46
<u>Total</u>	<u>581.17 lb/50 gal</u>

Claims

1. Composition comprising

a) an oil soluble, water insoluble 3-isothiazolone compound of the formula:



15

wherein Y is an alkyl group of 2 to 18 carbon atoms optionally substituted with hydroxy, halo, cyano, alkylamino, dialkylamino, phenylamino, halophenylamino, carboxy, carbalkoxy, alkoxy, aryloxy, morpholino, piperidino, pyrrolidonyl, carbamoxy, or isothiazolonyl, wherein the total number of carbon atoms in the substituted alkyl group does not exceed 18; an unsubstituted or halo-substituted alkenyl group of 4 to 18 carbon atoms; an unsubstituted or halo-substituted alkynyl group of up to 18 carbon atoms; an unsubstituted or alkyl-substituted cycloalkyl group having a four to six carbon atom ring and up to 12 carbon atoms; an unsubstituted or a halo-, lower alkyl-, or lower alkoxy-substituted aralkyl group wherein the total number of carbon atoms in the aralkyl group does not exceed 10; or an unsubstituted or a halo-, nitro-, lower alkyl-, or lower carbalkoxy- substituted aryl group wherein the total number of carbon atoms in the aryl group does not exceed 10; and

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25

R and R¹ are each independently hydrogen, halogen, or a (C₁-C₄) alkyl group;

30

b) copper dodecylbenzene sulfonate, and/or copper dioctyl sulfosuccinate and/or copper petroleum sulfonate in an amount sufficient to stabilize said isothiazolone against chemical degradation;

35

c) optionally an organic solvent.

2. Composition according to Claim 1 wherein said 3-isothiazolone is 2-n-octyl-3-isothiazolone, 4,5-dichloro-2-cyclohexyl-3-isothiazolone, or 4,5-dichloro-2-n-octyl-3-isothiazolone.
3. Composition according to claim 1 or 2 which comprises from 0.01 to 50, preferably from 1 to 25 parts by weight of said isothiazolone; from 0.0001 to 10, preferably from 0.1 to 10 parts by weight of said copper compound; and from 40 to 99.9899, preferably from 65 to 98.9 parts by weight of a solvent.
4. Composition according to any preceding claim, wherein the ratio of isothiazolone to copper compound is from 50:1 to 1:3, preferably from 10:1 to 1:2.
5. Method of stabilizing a 3-isothiazolone as defined in claim 1 or 2 against chemical decomposition, comprising incorporating therewith an effective amount of copper dodecylbenzene sulfonate, copper dioctyl sulfosuccinate and/or copper petroleum sulfonate.
6. Use of copper dodecylbenzene sulfonate, copper dioctyl sulfosuccinate or copper petroleum sulfonate as a stabilizer for 3-isothiazolones.
7. Method of preventing or inhibiting the growth of bacteria, fungi or algae in a locus susceptible or subject thereto, comprising incorporating into or onto the locus, in an amount effective to adversely affect said growth, a composition according to any one of claims 1 to 4.
8. Method according to claim 7, wherein the locus is a coating or impregnant composition, preferably a paint; a marine antifoulant composition, a metal working fluid, or a wood preservative.
9. Article containing as a microbicide a composition according to any of claims 1 to 4, said article preferably being a coating or impregnant composition, more preferably a paint; a marine antifoulant composition, a metal working fluid, or a wood preservative.
10. Composition comprising from 0.01 to 30% by weight of a composition according to any of claims 1 to 4 in water, and an emulsifier.



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which under Rule 45 of the European Patent Convention
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Application number

EP 91311269.4

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int Cl')
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
P, A	<u>EP - A - 0 425 143</u> (ROHM AND HAAS COMPANY) * Claims 1,2,8 *--	1,5,6, 9	C 07 D 275/03 A 01 N 43/80
D, A	<u>US - A - 4 067 878</u> (MILLER et al.) * Claims 1,7,14 *--	1,5,9	
A	<u>US - A - 4 031 055</u> (DUPONT et al.) * Claims 1,11,13 *--	1,5,6, 9	
A	<u>US - A - 3 870 795</u> (MILLER et al.) * Claim 1 *----	1,5	
INCOMPLETE SEARCH			TECHNICAL FIELDS SEARCHED (Int Cl')
			C 07 D 275/00
The Search Division considers that the present European patent application does not comply with the provisions of the European Patent Convention to such an extent that it is not possible to carry out a meaningful search into the state of the art on the basis of some of the claims. Claims searched completely: 1-6,8-10 Claims searched incompletely: 7 Claims not searched: - Reason for the limitation of the search: Method for treatment of the human or animal body by therapy (EPC Art. 52(4))			
Place of search VIENNA	Date of completion of the search 04-03-1992	Examiner BRUS	
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X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			